



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4753-1

Job Sheet 177081



Part No: D4753-1

Job Qty: 50 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/4/18

Job Tracking No:

Due Date: 5/11/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		5/11/18	0.00	0.00	Start Up Waterjet		SC 18/05/08
100	Waterjet	50 pcs		5/11/18	0.00	1.50	Waterjet1		SC 18/05/08
110	QC	50 pcs		5/11/18	0.00	0.00	QC2 Waterjet-1		SC 18/05/08
120	CNC Vertical Machining	50 pcs		5/11/18	0.02	3.60	HAAS1-5		
140	QC	50 pcs		5/11/18	0.00	0.00	QC8		SC 18/05/22
150	Small Fab	50 pcs		5/11/18	0.00	0.59	Small Fab-7		SA 18-05-24
160	QC	50 pcs		5/11/18	0.00	0.00	QC5		SA 18-05-24
170	HandFinish	50 pcs		5/11/18	0.00	0.42	HandFinish1		SA 18-05-24
180	QC	50 pcs		5/11/18	0.00	0.00	QC7-4		SA 18-05-24
190	Packaging	50 pcs		5/11/18	0.00	0.00	Packaging3-2		SA 18-05-24
200	QC21-SA	50 Ea		5/11/18	0.00	0.00	QC21		SA 18-05-24

Part Op 100 - 1-Cut as per Dwg D4753 Dwg Rev: A Prog Rev: A ***.758" DIA HOLE TO BE OPENED TO FIN
 Descriptions: SIZE BY SKID DEPARTMENT UPON INSTALLATION** 3- Deburr if necessary
 120 - Machine as per Folio FB163 and Dwg D3506 FOLIO REV: _____ DWG REV: _____ ***.758" DIA HOLE
 TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT UPON INSTALLATION**
 150 - C'sink as per Dwg D4753 (On Flat side)
 190 - LOCATION : LG001

M138346 Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	.6900 sf (.0138 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	1	114	0

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Container No: S069627

DART
AEROSPACE



Part: D4753-1
Job No: 177081
Serial No/Batch: S069627
Revision:
Inspector:

Date: 05/09/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128Inches + 0.005 - 0.001	0.133 0.127	0,128	Diameter
2	Doubler	0.500Inches ± 0.010	0.510 0.490	0,503	
3	Doubler	1.000Inches ± 0.010	1.010 0.990	1,001	
4	Doubler	0.750Inches ± 0.010	0.760 0.740	0,751	
5	Doubler	1.500Inches ± 0.010	1.510 1.490	1,500	
6	Doubler	2.000Inches ± 0.010	2.010 1.990	1,996	
7	Doubler	0.126Inches ± 0.010	0.136 0.116	0,125	
8	Doubler	3.540Inches + 0.012 - 0.001	3.552 3.539	3.54	Diameter
9	Doubler	0.126Inches ± 0.010	0.136 0.116	0,123	

Plex 5/4/18 2:23 PM Dart.Gagnon.Michelle